



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3370-1
Job Sheet 200379



Part No: D3370-1

Job Qty: 6 pcs

Part Name: Pedal Lock Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP B 05.05.25 Added Powder Coat KJ/JLM IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		10/8/19	0.00	4.51	Bandsaw - 1		SBL 19/09/28
110	HAAS 4 Axis - B4B	6 pcs		10/8/19	0.37	4.51	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/09/28
							HAAS - 4 - B4B		
120	QC 2	6 pcs		10/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 19/09/28
							QC 2 - 62		



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CANADA
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www.dartaerospace.com

Container No: S218075



Part: D3370-1

Job No: 200379

Serial No/Batch: S218075

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/28/19

Plex 9/10/19 3:15 PM Dart.lajeunesse.marie

130 QC 8	6 pcs	10/8/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	on 19/09/28
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	10/8/19	0.00 0.53	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 30 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	

					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Powdercoat - 6 Fire Red - B4B	6 pcs	10/8/19	0.00	0.28	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	6 pcs	10/8/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	6 pcs	10/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

BL 19-10-01

DAS
40
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OCT 01 2019

smf
19/10/19

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6	10/8/19	0.00 0.00	QC 21 - SA - 21	DAG
	pcs			QC 21 - SA - 70	21 OCT 01 2019
				QC 21 - SA - 53	9-59

Part Op 100 - Cut blank: 1.500" x 2.500" x 4.120" long
 Descriptions: 110 - (HAAS CNC Vertical Machine), Machine D3370-1 as per Folio FA482 and Dwg D3370 Identify as D3370-1 Dwg
 Rev: 2
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Fire Red(Ref:4.3.5-10) per QSI005 4.3), Heat oven at temperature for 45 minutes before putting part in oven
 by: Start Time: 7:00 Oven Temperature: 320° Finish Time: 8:00 11/12/2023
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	2,000 ea 3,483	100-Bandsaw - 1	S207687 S207687

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	2	51	0

Part Specifications

Specifications could not be found.

Plex 9/10/19 3:15 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 200379
Description: Pedal Lock Base		Part Number: D3370-1
Inspection Dwg: D3370	Rev: C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	1.999			VIX-02	
0.202	+/-0.010	.208				
0.592	+/-0.010	.593				
0.550	+/-0.010	.552				
0.760	+/-0.010	.765				
1.50	+/-0.030	1.500				
1.188	+/-0.010	1.188				
1.232	+/-0.010	1.231				
R0.500	+/-0.010	.500				
2.35	+/-0.030	2.348				
1.920	+/-0.010	1.918				
0.450	+/-0.010	.447				
1.673	+/-0.010	1.670				
2.638	+/-0.010	2.630				
4.00	+/-0.030	3.998				
Ø0.203	+0.005/-0.000	.204				
0.250	+/-0.030	.250				
1.450	+/-0.005	1.454				
0.450	+/-0.010	.456				
15°	+/-0.1°	15°				

Measured by: DAS 57	Checked by: [Signature]	QC Inspector:
Date: 9-89 19/09/28	Date: 19/09/28	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	
D	16.02.19	Dwg Rev updated to Rev C	KJ	[Signature]



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____
Part No. _____

DISPOSITION		DEPARTMENT/PROCESS			
☐ Rework ☐ Scrap ☐ Use-as-is	☐ Skid-tube ☐ Machining ☐ Large Fab	☐ Cross tube ☐ Small Fab ☐ Finishing	☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging	☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	
Date: _____		Sequence #: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
		QTY Affected: _____			
		Completed By			
		Lead hand / Supervisor			
QC / QA Coordinator					
Root Cause		FAULT CATEGORY			
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:					